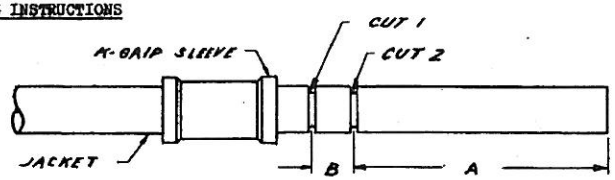
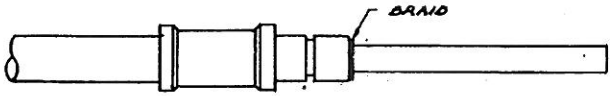
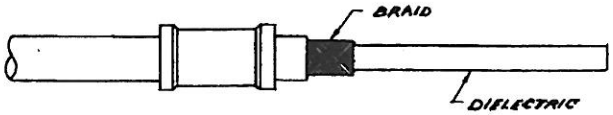
CABLING INSTRUCTIONS



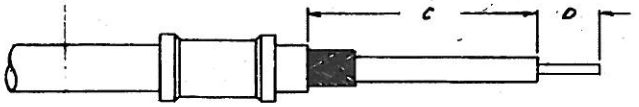
1. CUT CABLE END SQUARE. SLIDE K-GRIP SLEEVE OVER JACKET AND WITH JACKET TRIM JIG MAKE CUTS 1 AND 2 IN JACKET.



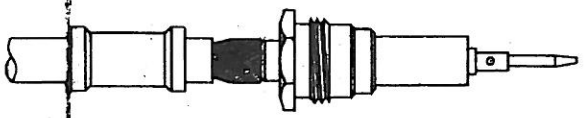
2. REMOVE JACKET TO A DIMENSION. FLARE OVER OR BULGE BACK BRAID AND TRIM WITH SCISSORS AT EDGE OF JACKET.



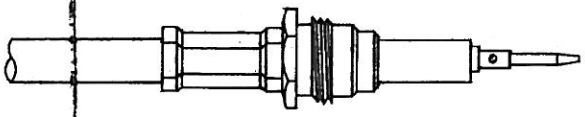
3. REMOVE JACKET TO B DIMENSION.



4. USING DIELECTRIC TRIM JIG, TRIM C DIM. EXPOSED CENTER CONDUCTOR LENGTH WILL BE EQUAL TO D DIMENSION.



5. PUSH K-GRIP ... OVER DIELECTRIC AND UNDER BRAID UNTIL DIELECTRIC BOTTOMS IN K-GRIP ASSEMBLY.



6. SLIDE K-GRIP SLEEVE AGAINST SHOULDER ON K-GRIP BODY AND FORM HEX. CRIMP CONTACT IS READY TO BE CRIMPED OR SOLDERED TO CENTER CONDUCTOR. CRIMP OR SOLDER THE CONTACT AND THREAD K-GRIP ASSEMBLY INTO BODY ASSEMBLY.

UNLESS OTHERWISE SPECIFIED:

1. TOLERANCES: FRACTIONS & 2 PLACE DECIMALS ± .010
   3 PLACE DECIMALS ± .004 ANGLES ± 0° 30'
   T. I. R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.
2. REMOVE ALL BURRS. BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICROINCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.

ITEM	REQ'D	DESCRIPTION	DRAWING NO.

V-59-39-12

REVISIONS	
ISSUE	CHANGES
1	CN 15279A MJB 6 JAN 76

REF:
FINISH
SPEC.
MATL.
SPEC.

CABLING INSTRUCTIONS

DRAWN F. C.	DATE 13 MAY 70
APPR. MS	DATE 13 NOV 70

KINGS ELECTRONICS
40 MARBLEDALE ROAD
TUCKAHOE, N. Y. 10707

V-59-39-12

SHEET 1 OF 2

MAY 2007 THIS DRAWING BECAME THE PROPERTY OF PROPERTY OF
WINCHESTER ELECTRONICS CORPORATION, WALLINGFORD, CT 06492

DASH NO.	DESCRIPTION	MADE FROM

V-59-39-12

CABLE GROUP RG-( )/U	CONNECTOR	BODY ASSEMBLY	K-GRIP ASSEMBLY	TRIM CODE CP-	DIMENSIONS A	B	C	D	JACKET TRIM JIG KTJ-	DIELECTRIC TRIM JIG KTD-	CRIMP DIE SIZE **	K-GRIP SLEEVE I.D. REF.
174, 187*, 188, 188A 187A*, 179A*, 179B*	KV-59-11	V-59-11-3	V-59-11-1	447	1 15/64	5/32	.953	9/32	103	141	71	.12
	KV-59-39	V-59-39-7	V-59-39-8									
	1705-3	2-42-1	2-89-1									
58*, 58A*, 58C 141*, 141A	KV-59-47	V-59-39-7	V-59-47-1	451	1 7/64	3/16	1.018	9/32	98	149	61	.21
	1705-5	2-42-1	2-90-1									
59, 59A, 59B, 62 62A, 62C, 210	KV-59-48	V-59-39-7	V-59-48-1	451	1 7/64	3/16	1.018	9/32	98	148	62	.26
	1705-6	2-42-1	2-91-1									
8, 8A, 11* 11A*, 213	KV-59-49	V-59-50-2	V-59-49-1	452	1 1/8	3/16	.690	5/8	99	147	78	.42
	1705-7	2-47-1	2-92-1									
9, 9A, 9B, 214	KV-59-50	V-59-50-2	V-59-50-1	452	1 1/8	3/16	.690	5/8	99	147	79	.44
	1705-8	2-47-1	2-92-1									

NOTES:

** USE IN KINGS CRIMPING TOOL KTH-1000.

* CENTER CONTACT MUST BE SOLDERED.

1. INSTRUCTION SHEET TO BE WHITE SULPHUR FREE PAPER.

UNLESS OTHERWISE SPECIFIED:

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   3 PLACE DECIMALS ± .004 ANGLES ± 0° 30'
   T. I. R. CONCENTRICITY OF ANY 2 DIAMETERS MAY NOT EXCEED HALF THE SUM OF THEIR TOLERANCES.
2. REMOVE ALL BURRS. BREAK SHARP EDGES .005 MAX.
3. NO FILLETS PERMITTED.
4. SURFACE ROUGHNESS 63 MICROINCHES RMS MAX.
5. ALL DIMENSIONS PRIOR TO PLATING.

ITEM	REQ'D	DESCRIPTION	PART NO.

REVISIONS

ISSUE	CHANGES

USED ON:

REF:

FINISH

SPEC.

MATL.

SPEC.

CABLING INSTRUCTIONS

DRAWN	M.J.B	DATE	6 JAN 76
APPR.	J.M.	DATE	14 JAN 76

KINGS ELECTRONICS
40 MARBLEDALE ROAD
TUCKAHOE, N. Y. 10707

V-59-39-12

SHEET 2 OF 2

MAY 2007 THIS DRAWING BECAME THE PROPERTY OF PROPERTY OF
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